

Work Order ID 79955

February-08-12 10:14:51 AM

\*79955\*

U/R

Page 1

Item ID: D412-742-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID: U/R OK 08.02.08

Item Name: Replacement Float Skidtube

Stop \*NS2\*

Start Date: 08/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 22/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/02/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3391 I

100 0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on its own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG005

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D412-742-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID: U/R

Item Name: Replacement Float Skidtube

Stop

\*NS2\*

Start Date: 08/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 22/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

\*110\*

HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex

✓ 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using  
7/16" "T" Pins.

A/RSikaflex-241/291 A1119508

Expiry date: 12/08

✓ 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against  
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except  
ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/291 A1119508

Expiry date: 12/08

✓ 3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with  
MEK degreaser.

✓ A/RLPS Procyon A1114596

**Dart Aerospace Ltd**

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Page 3

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Item ID:	D412-742-043	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:	U/R					
Item Name:	Replacement Float Skidtube				Stop	<b>*NS2*</b>
Start Date:	08/02/2012	Start Qty:	1.00	<b>*1*</b>	Cust Item ID:	
Required Date:	22/02/2012	Req'd Qty:	1.00	<b>*1*</b>	Customer:	

**Reference:**

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
							Stop
	QC:	Date:	SPC (Y/N):	Date:			<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>MJ 12-02-27(1)</i>
130 <b>*130*</b> Packaging	Packaging Memo	0.00 0.00							<i>(R SP 12-02-28</i>
140 <b>*140*</b> QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>MIC 12/02/28 12-02-28</i>

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**Picklist Print**

February-08-12 10:14:55 AM

Page 1

Work Order ID: 79955

**\*79955\***

Parent Item: D412-742-043

**\*D412-742-043\***

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM

IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC

IPP Rev:C 07-05-28 As per Rev F JLM

IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F

11.11.01 as per DSI9517 REV.B DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3391-021		Manufactured	No		110	Each	0.0000		1	1	**	B77383 (x1) Ml 12/02/27
<b>*D3391-021*</b> Fwd Tube Assembly												
D3391-023		Manufactured	No		110	Each	0.0000		1	1	**	B80277 (x1) Ml 12/02/27
<b>*D3391-023*</b> Mid Tube Assembly												

Location      Loc Qty      Loc Code

FP      1      \_\_\_\_\_

GA      -1      \_\_\_\_\_

D3391-025		Manufactured	No		110	Each	1.0000		1	1	**	B77370 (x1) Ml 12/02/27
<b>*D3391-025*</b> Aft Tube Assembly												

Location      Loc Qty      Loc Code

FP001      1      \_\_\_\_\_

73018      1      \_\_\_\_\_

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Parent Item: D412-742-043

**\*D412-742-043\***

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

110

Each

3,795.000

24

24

\*\*

JL 1102127

**\*AN3C4A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	3795	
117313	2	
117688	5	
117872	10	
118112	16	
118451	2	
119749	260	
120187	2000	
120423	500	
<u>120521</u>	1000	XZ4

AN3C6A

Purchased

No

110

Each

344.0000

10

10

\*\*

JL 1102127

**\*AN3C6A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	343	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	25	
<u>120423</u>	250	V10

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Page 3

Work Order ID: 79955

**\*79955\***

Parent Item: D412-742-043

**\*D412-742-043\***

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 85.0000 4 4 \*\* M 1102127**\*AN3C7A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	85	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
<u>119749</u>	42	XJ

AN960C10L NAS1149C0332 R Purchased No 110 Each 0.0000 38 38 \*\* M 1102127 (x38) M 1102127**\*AN960C10I\***

washer

D4095-041 Manufactured No 110 Each 13.0000 1 1 \*\* M 12102127**\*D4095-041\***

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	13	
77438	3	
<u>78938</u>	10	V1

D4095-043 Manufactured No 110 Each 3.0000 1 1 \*\* M 12102127**\*D4095-043\***

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	3	
77437	3	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Work Order ID: 79955

**\*79955\***  
**\*D412-742-043\***

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

D4095-045

Manufactured No

110

Each

12.0000

1

1

\*\*

M 1022

**\*D4095-045\***

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	12	
77737	1	
<u>79042</u>	11	X\

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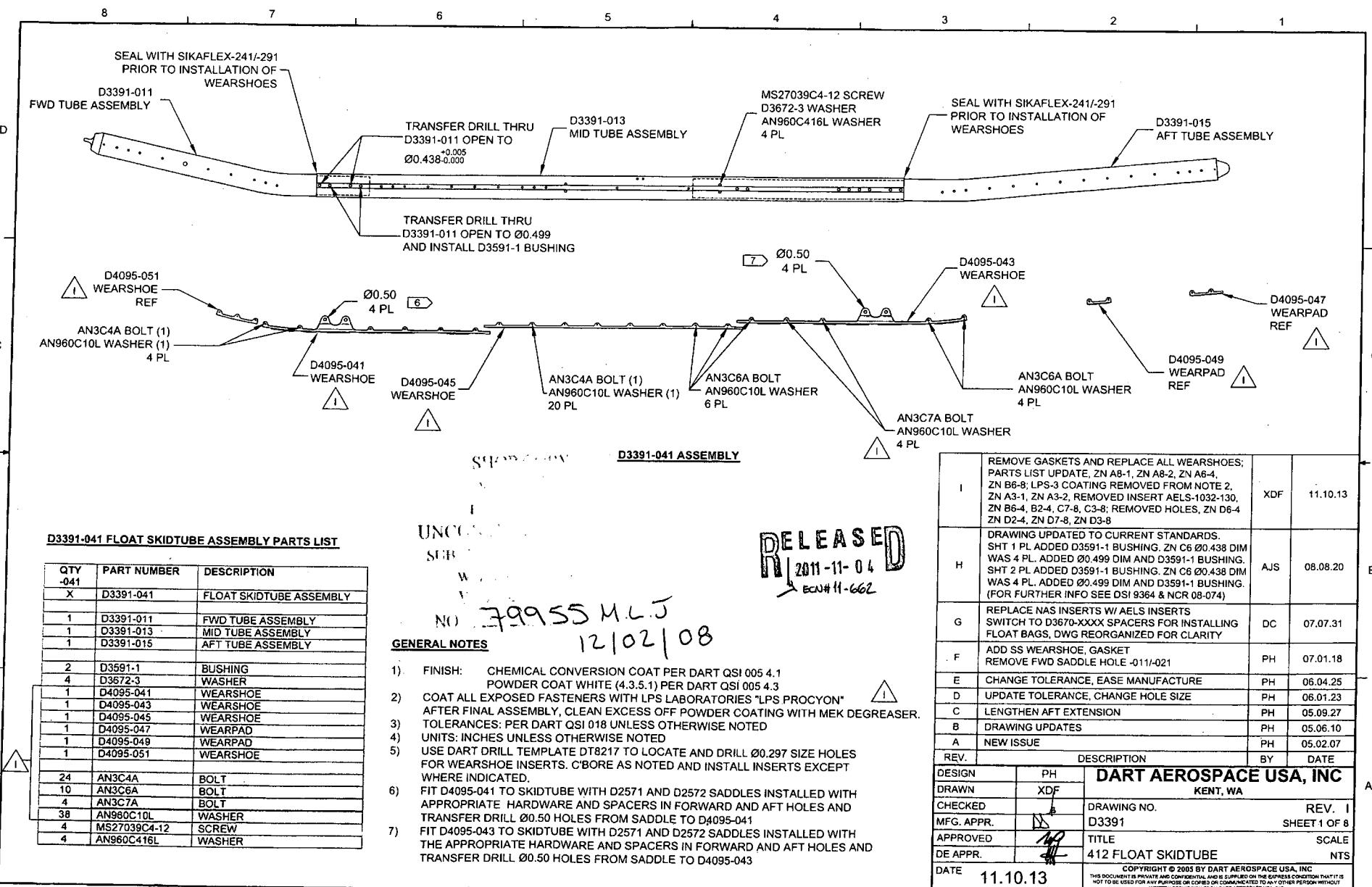
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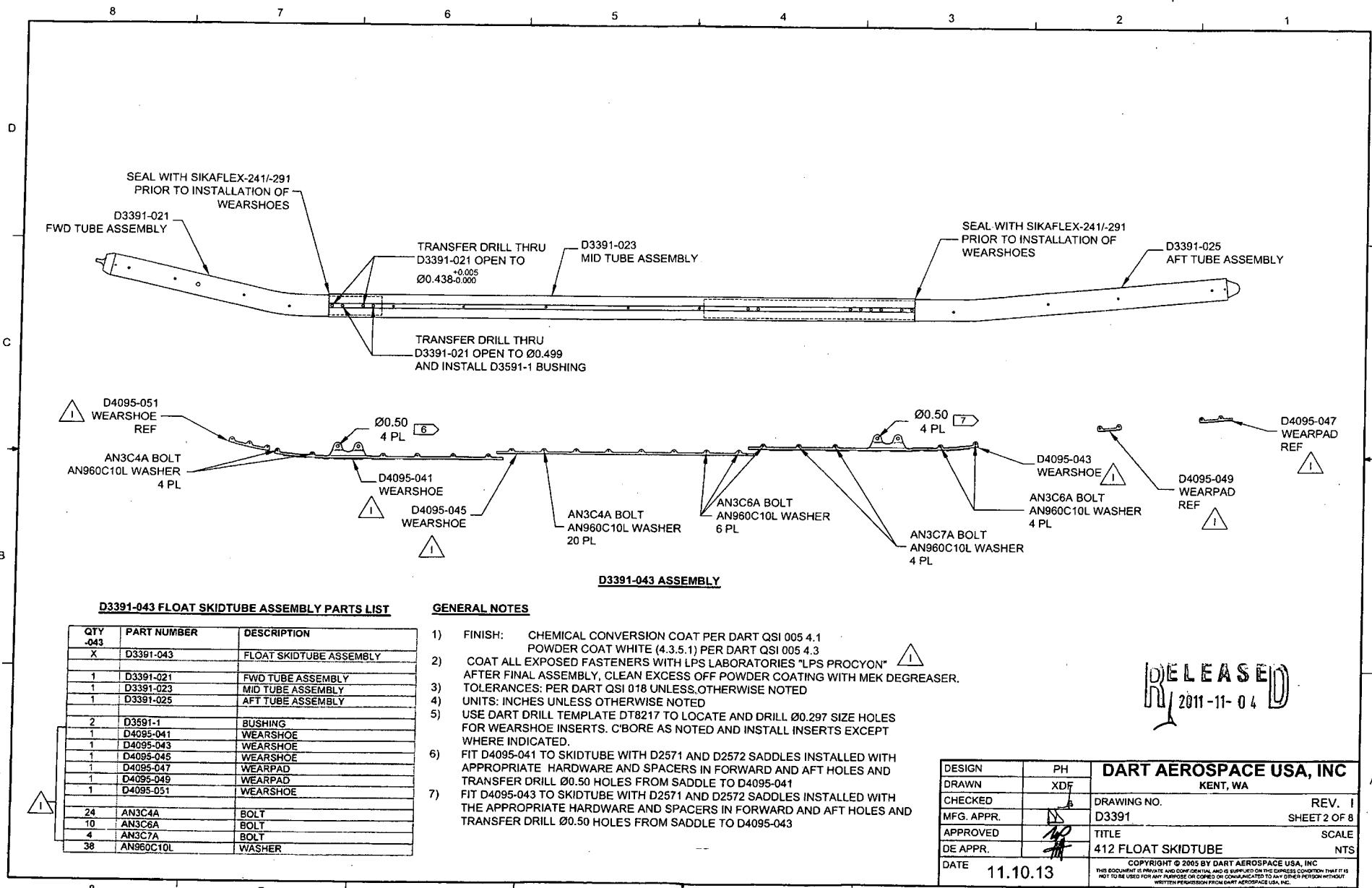
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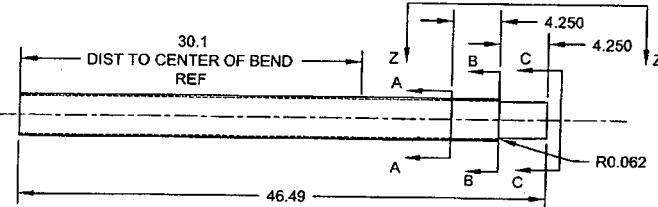
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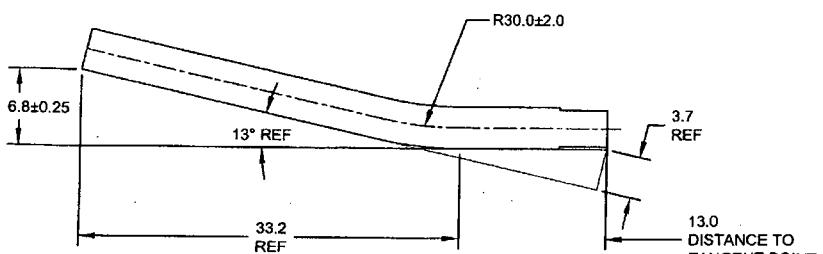
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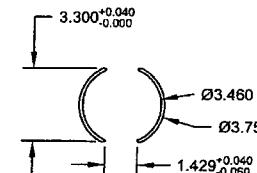
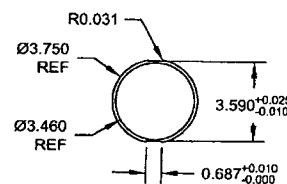
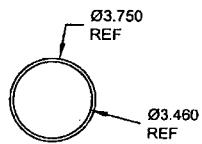
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)

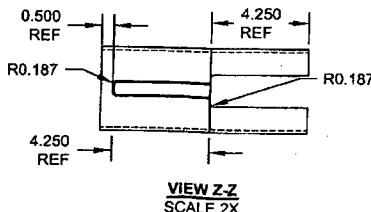
C

C



B

B



A

RELEASED  
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED		DRAWING NO.
MFG. APPR.		D3391
APPROVED		REV. 1
DE APPR.		SHEET 3 OF 8
		TITLE
		412 FLOAT SKIDTUBE
		SCALE
		NTS
DATE	11.10.13	

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**Dart Aerospace Ltd**

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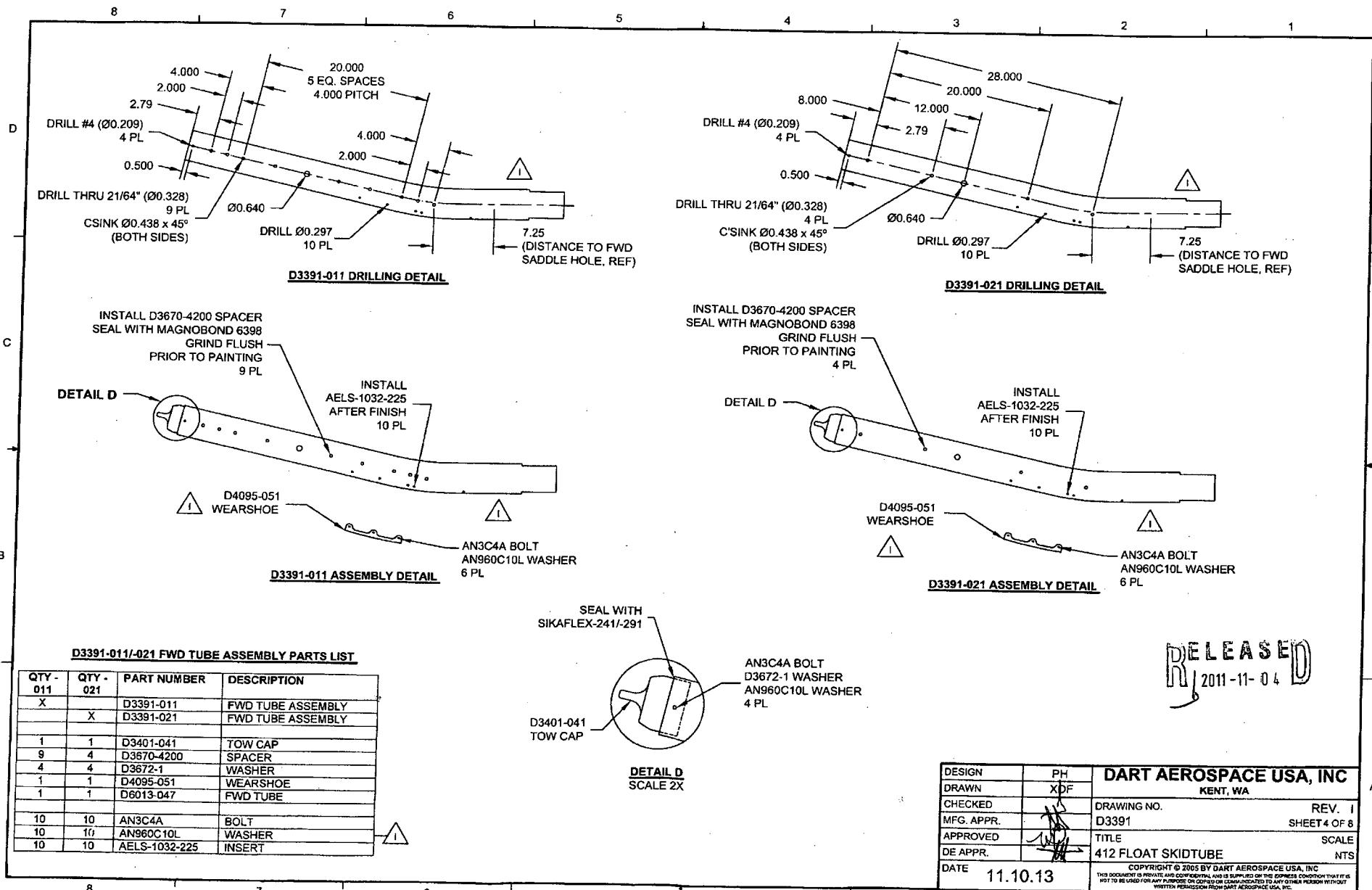
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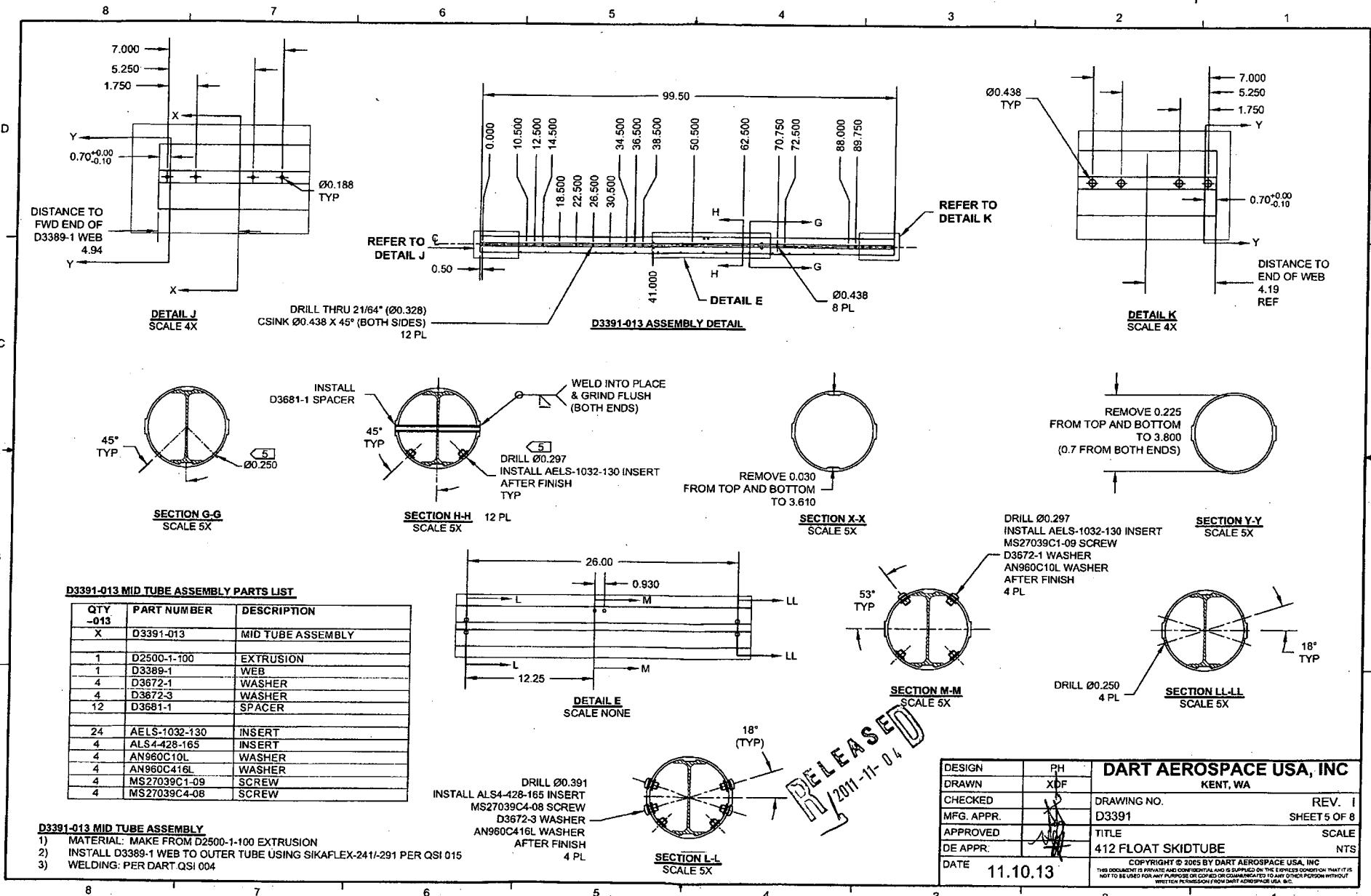
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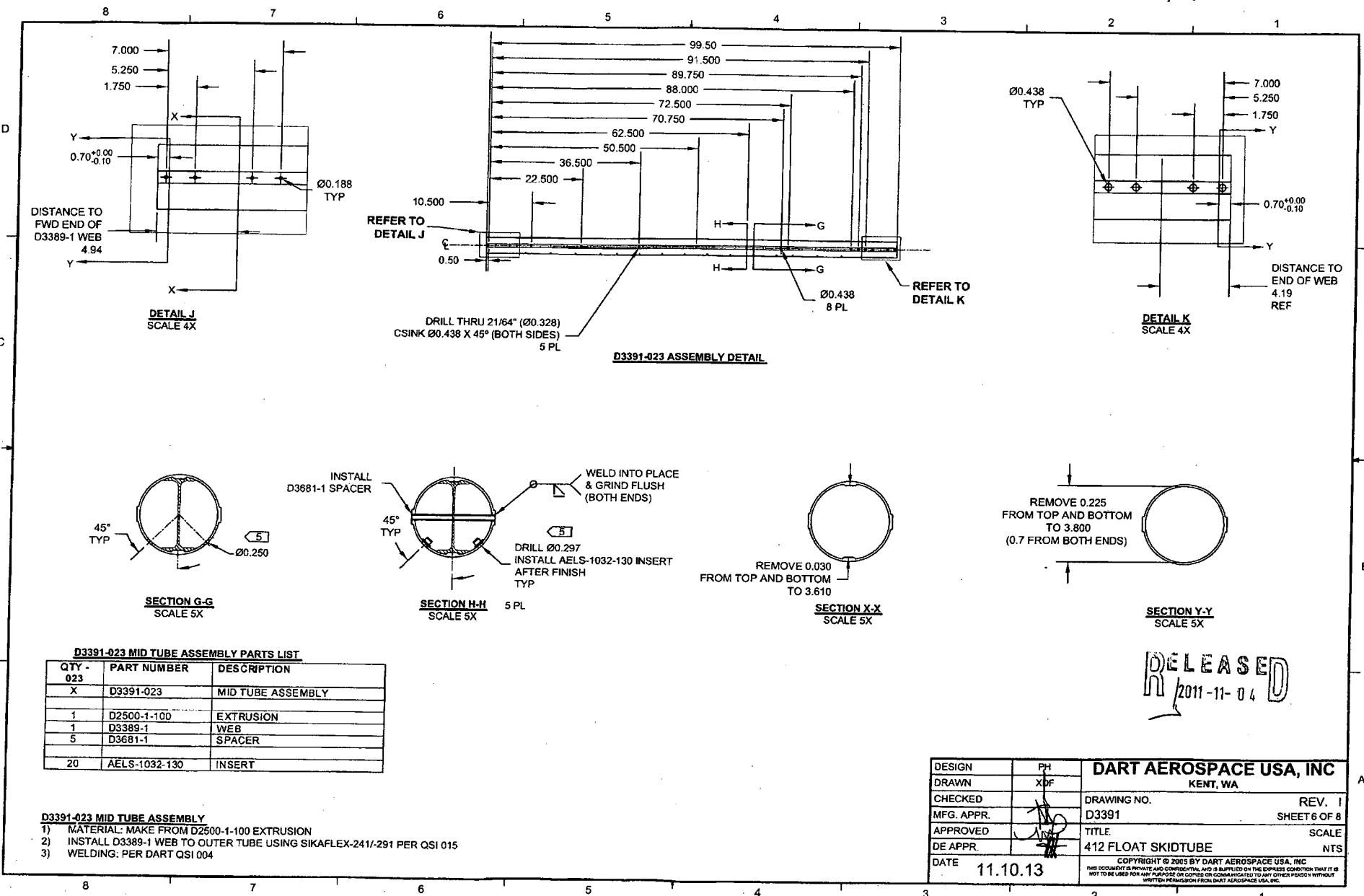
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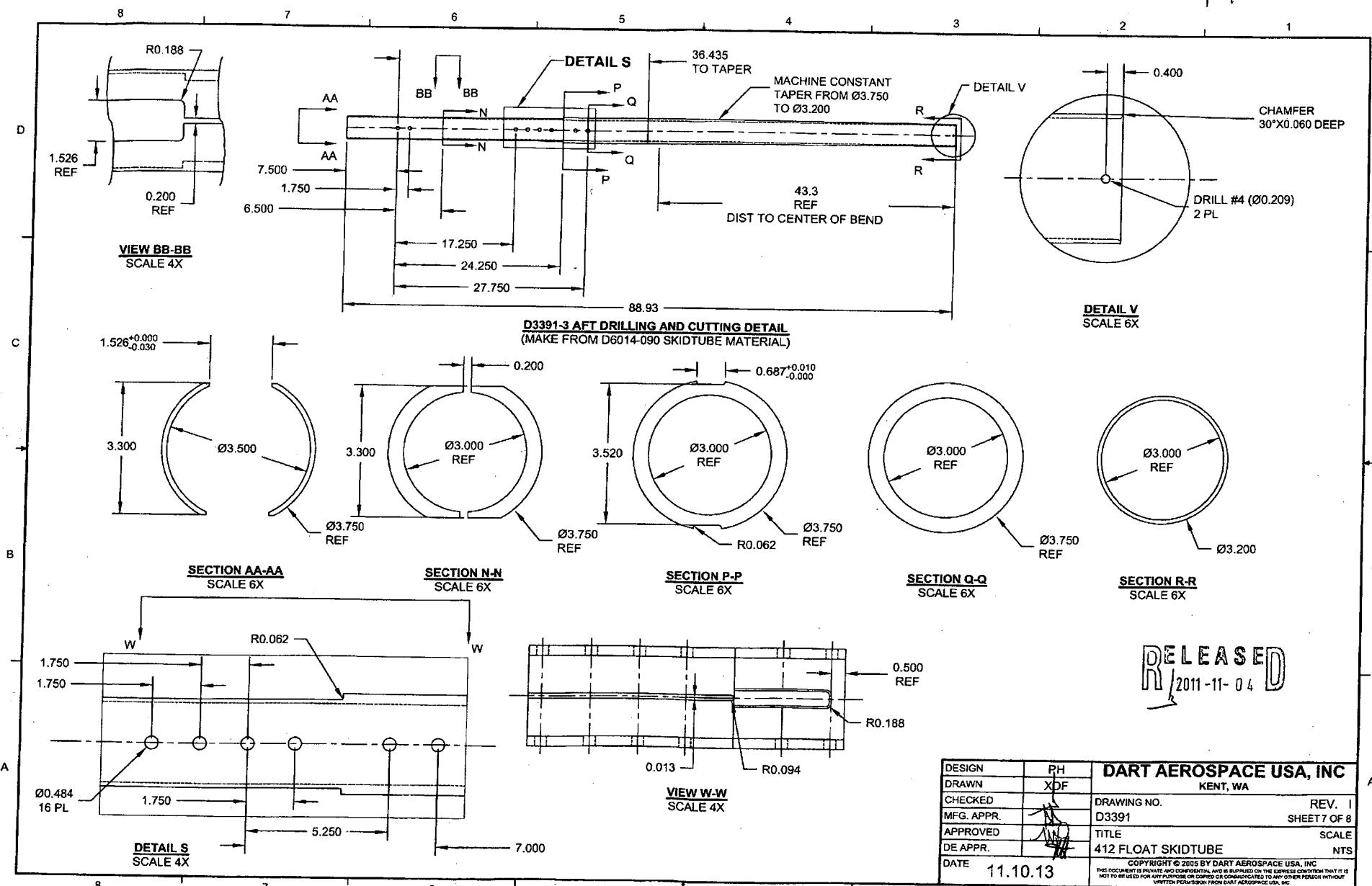
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RELEASED  
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED		DRAWING NO.	REV. I	
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 7 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS	
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS REPRODUCED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT				

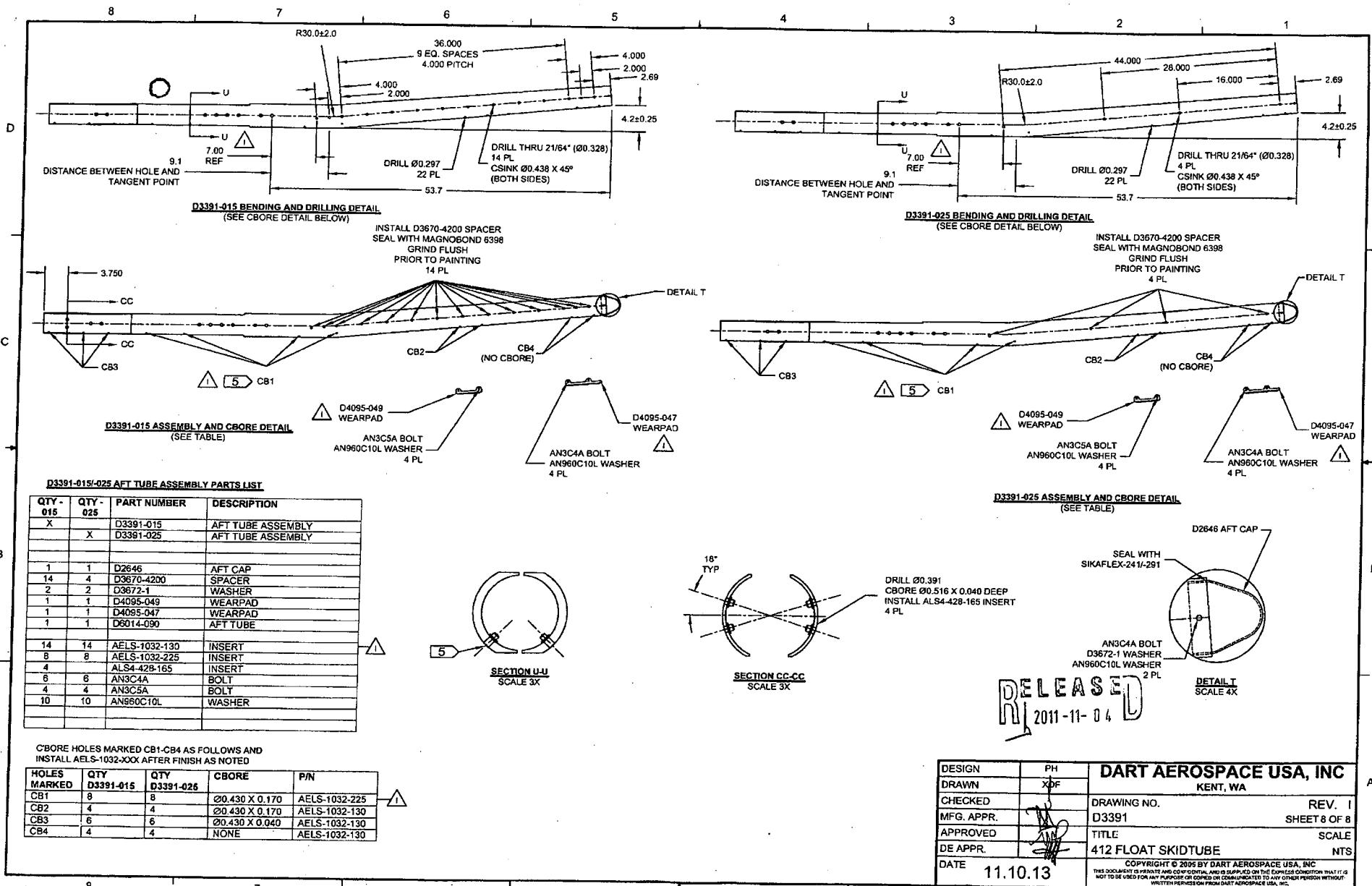
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								<input type="radio"/>	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries